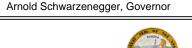
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-000938 Address: 333 Burma Road **Date Inspected:** 19-Nov-2007

City: Oakland, CA 94607

OSM Arrival Time: 600 **Project Name:** SAS Superstructure **OSM Departure Time:** 1530 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes No Huang Wei **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No **Delayed / Cancelled:** Yes N/A No

34-0006 **Bridge No: Component:** HP2007259

Summary of Items Observed:

CalTrans Quality Assurance (QA) Inspector Dan Hernandez was on site at ZPMC Welding Lab to observe the welding of the Procedure Qualification Record (PQR) test plate HP2007259. PQR HP 2007259 is a multiple pass groove weld test coupon welding in the 1G position using the Flux cored arc welding (FCAW) process. Filler metal specification AWS A5.20 and classification E71T-1, electrode diameter 1.4 mm. Test plates were 26 mm thick with a 10 mm back up bar in a butt-Joint fit up. Welding was performed per AWS D1.5 2002, Section 5.13 Production Procedure WPS. Welding was performed by Xing Ji Zhan. QA Inspector observed passes 1-10 during the Day Shift. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Haung Wei and Bureau Veritas Inspector Mr. Arbin Huang were observed monitoring welding activities at the workstation.



WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer